

Work Order ID 57155

March 24, 2010 8:42:59 AM



Page 1

Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 24/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 07/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 10-3-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

F

100



DC

DOCUMENT CONTROL


0.00

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod ☒ M112507 / ~~M113207~~ BE 10-3-30

4-Grind weld flush to cap on top surface only. BE 10-3-30

5-Cut aft end to lenght as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

10-3-30

10-3-30

W/O:		WORK ORDER CHANGES					
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Date:

Run Start



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Date:

SPC (Y/N):

Date:

Stop

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DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

130

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.
cure time before cutting

Start Date: 10-3-10 Time: 2:30

Finish Date: 10/03/11 Time: 10:45 am

A/R: Sikaflex-291 112429

Sikaflex expiry date: 10/8/30

10-3-30

10-3-30

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>70</u>			
150 Skidtubes Skidtubes	Skidtubes Memo 1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. A/R <input type="checkbox"/> Aluminum Rod <u>M112507</u> 2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube 3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 4- Install nut plate as per dwg	0.00 0.00				<u>1</u>		DE 10/04/05	

10-4-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



HandFinish

HandFinishing

0.00

Memo

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D2650

0.00

*Just 10-04-05**N/A done on seq 150**DP 10-4-5*

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8-10-06

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*8-10-06**AD*

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

PL 10-4-7 ① φ.

200



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME: 10:30AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:00AM

⇒ LU 10/04/07

1 φ

210



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

① PL 10-4-19

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



HandFinish

HandFinishing

0.00

Memo

0.00

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☐ 112424 ☐Sikaflex expiry date: ☐ 10/08

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☐ 112409 ☐Sikaflex expiry date: ☐ 10/08

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: 1113545

HL 10-4-19 *D*

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

8/10/19

Quality Control

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/19

XL

Quality Control

250

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-642-341

Location:

PPP Rev:

PPP 57152

8/10/19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/27 *[Signature]*
ME
10-4-27

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Picklist Print

March 24, 2010 8:43:03 AM

Page 1

Work Order ID: 57155

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD416		Purchased	No				Each	8.0000	1.0000			
Washer												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST357	113 706	
	111279	8	
CCR264SS3-3	Purchased	No	
Cherry Rivet		Each	513.0000 2.0000

1 BR 10-4-19.

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST311	513	
	111548	16	
	111827	1	
	112314	2	
	113539	6	
	113973	488	
CR3212-4-03	Purchased	No	
Cherry Rivet		Each	236.0000 2.0000

10-4-5

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST311	236	
	111359	84	
	112314	152	

10-4-5

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Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2620		Manufactured	No				Each	8.0000	1.0000			
												
Skidtube, 206 Skidtube												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

8

8

Each

87.0000

1.0000

Manufactured No

55559

Handwritten: 10-3-30

D2647



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

87

87

Each

207.0000

19.0000

Manufactured No

55352

Handwritten: 1 BE 10/03/30

D2649



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

207

36013

5

47112

18

48271

4

51529

3

55000

177

Handwritten: 19 BE 10/04/05

March 24, 2010 8:43:03 AM

Shop Packet Print

Page 2

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Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2654-5		Manufactured	No				Each	2.0000	1.0000			
												
Web												

D2680-041



Nut Plate

Manufactured No

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	LG	2	
	46638	2	
		Each	51.0000

B52241

DP 10-4-30



ALS4-1032-130



Insert

Purchased No

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST021	51	
	33061	1	
	55366	50	
		Each	438.0000

220



DP 10-4-5

ALS7-1032-130

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST282	438	
	110511	438	

113288

54. BR 10-4-19.

March 24, 2010 8:43:03 AM

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Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960C10L		Purchased	No			220	Each	0.0000	54.0000			
washer												
AN960JD10L		Purchased	No			220	Each	3,003.000	2.0000			
Washer												

NAS 1149C0332R

113524

54. BL 10-4-19.

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST348

3003

101291

16

105793

49

110985 ✓

2938

Manufactured No

220

Each

41.0000

1.0000

2 BL 10-4-19.

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

FP6

36

46327

4

48109

4

52663 ✓

28

Main Warehouse

fp7

5

52663

5

1 BL 10-4-19.

D2646



Aft Cap

March 24, 2010 8:43:03 AM

Shop Packet Print

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2651-1		Manufactured	No			220	Each	348.0000	14.0000			

Plug

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

FP

51530

141

141

Main Warehouse

fpa

53349

207

207

220

Each

537.0000

14.0000

14. Bl 10-4-19

D2651-3

O-Ring

Manufactured

No

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

FP

43849

46114

537

3

534

14. Bl 10-4-19.

March 24, 2010 8:43:03 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 6

Work Order ID: 57155

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube


Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3535-11		Manufactured	No			220	Each	6.0000	1.0000			
												
Wearshoe												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

FP

6

46647 ✓

6

220

Each

14.0000

1.0000



D3535-23



Wearshoe

Manufactured

No

1 Bl 10-4-19.

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

FP

14

53467

2

56054 ✓

12

220

Each

9.0000

1.0000



D3535-35



Wearshoe

Manufactured

No

1 Bl 10-4-19.

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

FP

9

51608 ✓

9

1 Bl 10-4-19

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 7

Work Order ID: 57155

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D3536-11	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 220	Unit of Each	Qty on 14.0000	Remaining 1.0000	Qty	Date	Status
--------------------------------	-------------	----------------------	-----------	---------	------	--------------	-----------------	-------------------	---------------------	-----	------	--------

Gasket

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST497A

14

46649 ✓

10

46715

4

Manufactured No

220

Each

8.0000

1.0000

1 BL 10-4-19.

D3536-23



Gasket

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

FP

8

30754

1

53468 ✓

7

Manufactured No

220

Each

11.0000

1.0000

1 BL 10-4-19.

D3536-35



Gasket

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

FP

11

51628 ✓

11

1 BL 10-4-19.

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 8

Work Order ID: 57155

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3537-1		Manufactured	No			220	Each	53.0000	6.0000			
												
Wearpad												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

48288

55465

Main Warehouse

FP17

51678

Manufactured No

220

Each

24.0000

1.0000

D3537-3



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

33881

35697 ✓

24

4

20

6 BR 10-4-19.

1 BR 10-4-19

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 9

Work Order ID: 57155

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS27039-1-08		Purchased	No			220	Each	2,105.000	56.0000			
Screw												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST291	2105
110467	3
110552	102
110835	2000

MS27039-4-06

Purchased

No

220

Each

38.0000

1.0000

Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST292	38
109061	38

56 Bl 10-4-19.

1 Bl 10-4-19

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 57155

BS-0-3-24

RELEASED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP, DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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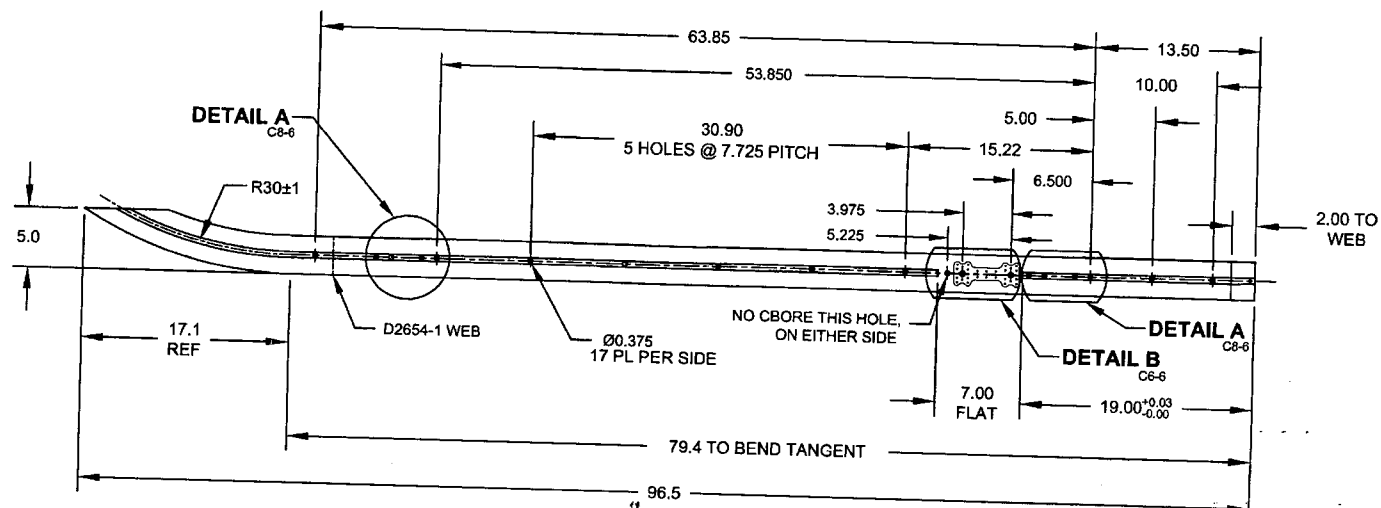
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

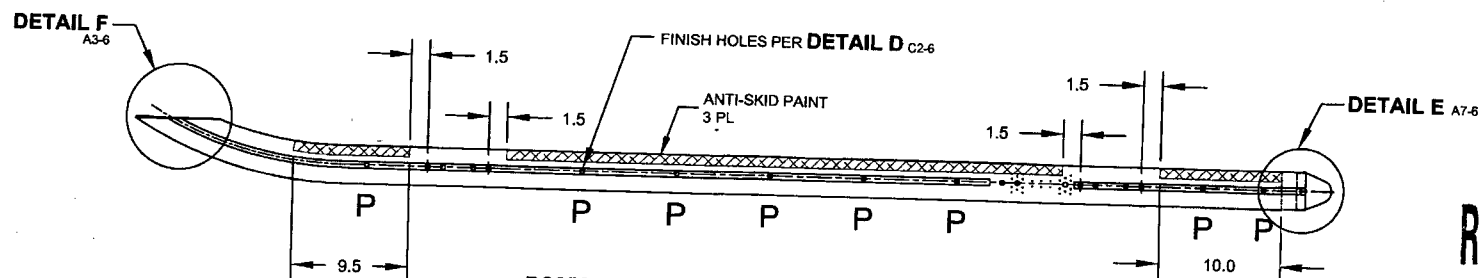
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

57155

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680922/117

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MFG. APPR.		D2650	SHEET 2 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

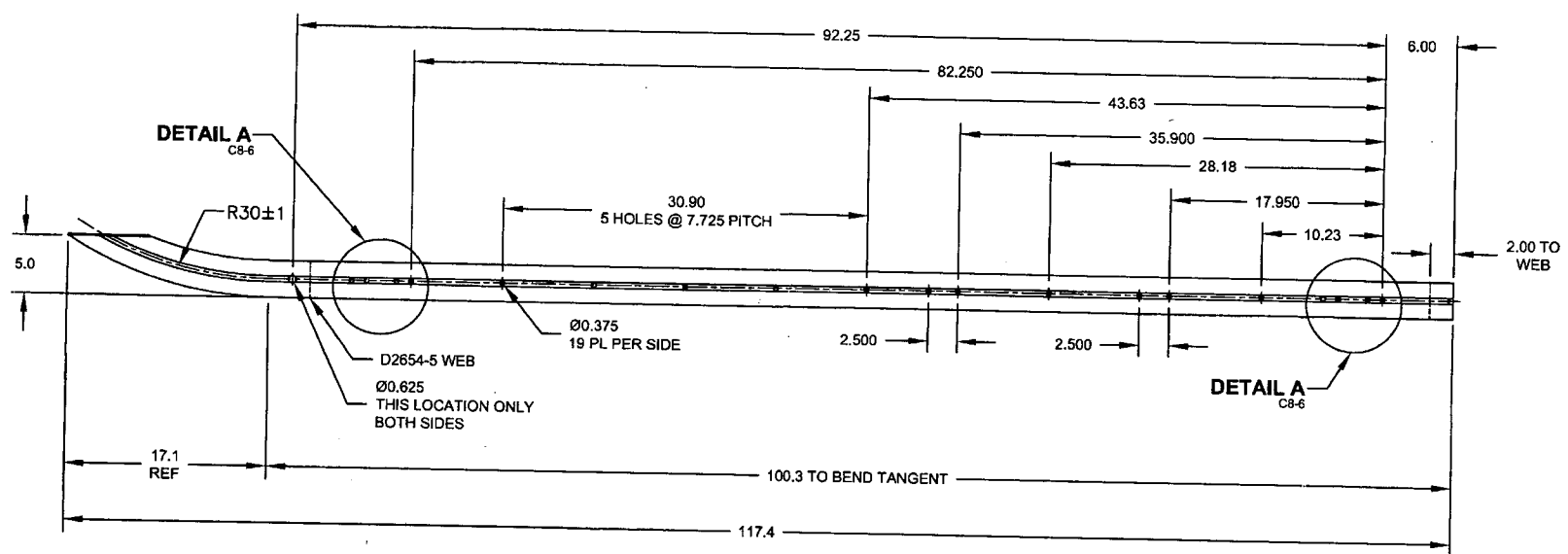
8 7 6 5 4 3 2 1

D

C

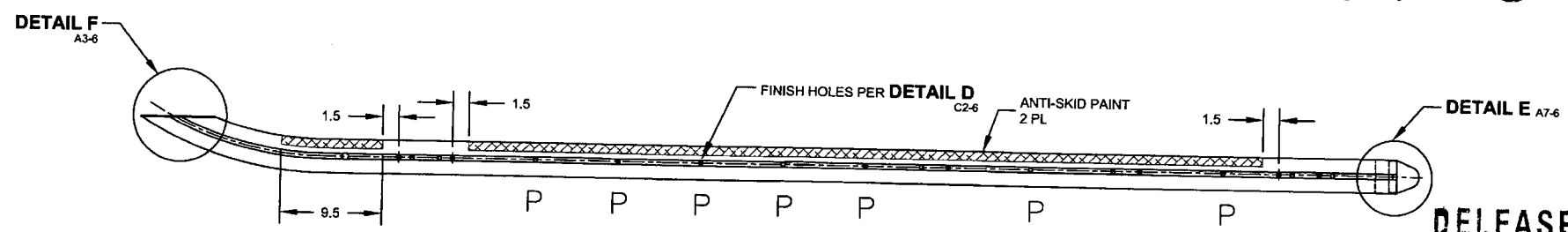
B

A



D2650-5 BENDING/DRILLING DETAIL

57155



D2650-5 ASSEMBLY/FINISHING DETAIL

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8 7 6 5 4 3 2 1

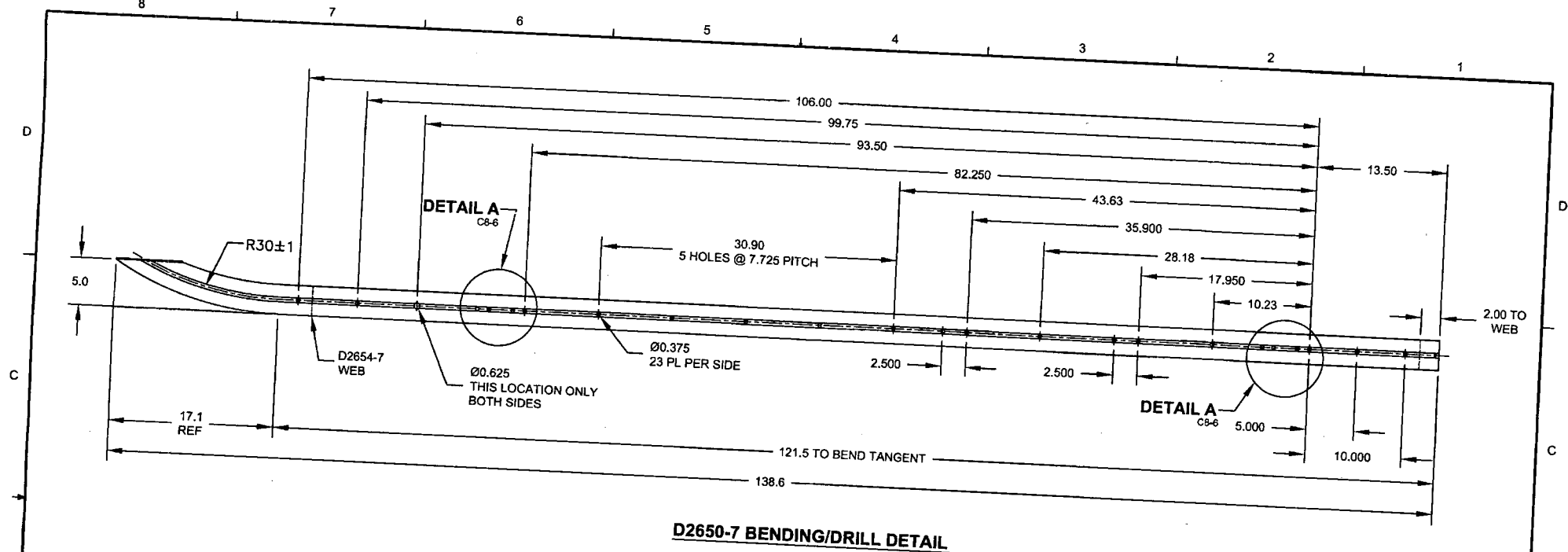
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

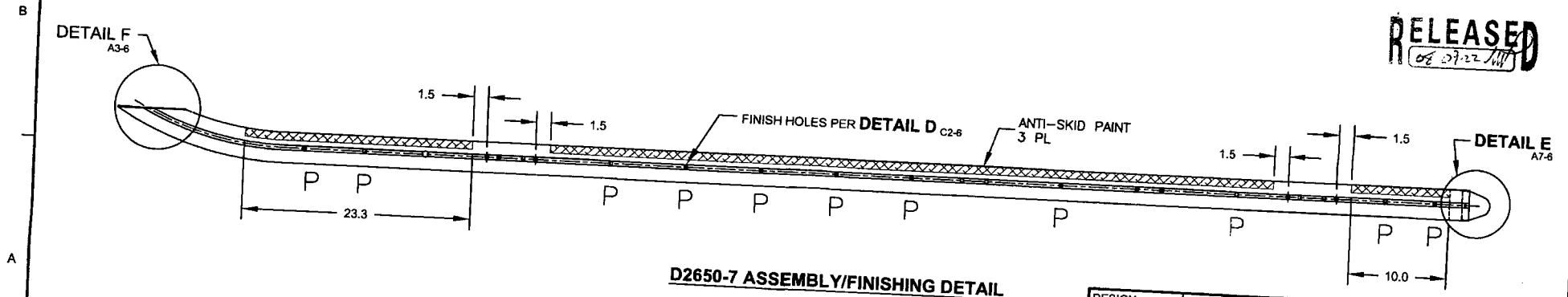
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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08 07 22



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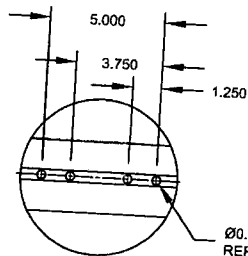
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

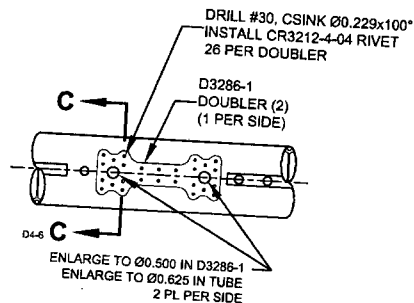
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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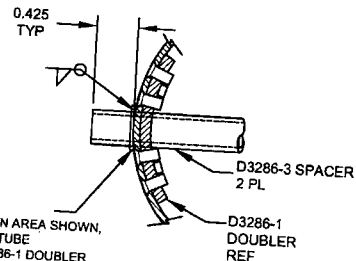


DETAIL A
SCALE 2X

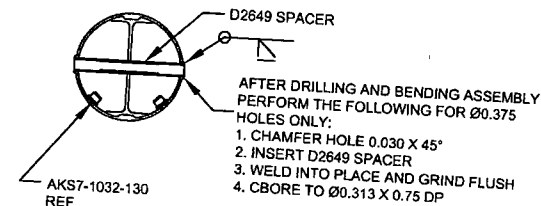


DETAIL B
SCALE 2X

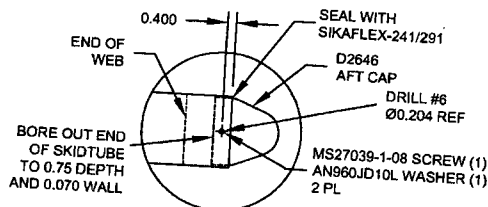
SECTION C-C
SCALE NONE



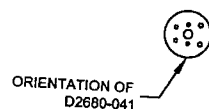
- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



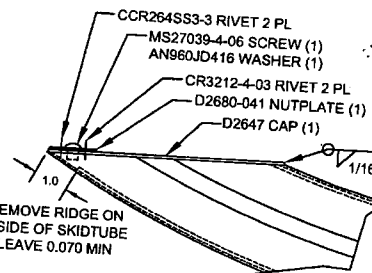
DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X



DETAIL E
SCALE 2X



REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN







DETAIL F
SCALE NONE

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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NOTE: Date & initial all entries

NO. 223

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Berclay Elliott
Job number: J 55777
Part number: 0206-642-441
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:

Undercut:

Pin holes:

Overlap (cold lap)

Porosity (surface):

Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Rab. Suf

Date of Test Coupon 10.02.16

Welder Berclay Elliott

Date of Test Coupon 10-02-16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld